

Work Order ID 66989

Thursday, March 03, 2011 10:03:01 AM

**PRELIMINARY
ISSUE** Accept



Page 1

Item ID: D4323-10
Revision ID: PRELIM
Item Name: Ceiling, Outboard RH

Start Date: 3/3/2011 Start Qty: 1.00
Required Date: 3/11/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:



Setup Start



Stop



Reference:

Approvals: Process Plan: [Signature] Date: 11-03-3 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4323	PA1 <u>PA3</u> <u>[Signature]</u>								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>24323 PA3</u> Prog Rev: <u>PA3</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B 11-3-7

9/50/03/08 ①

B 11-3-7

~~PRELIMINARY ISSUE~~ [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66989

Thursday, March 03, 2011 10:03:01 AM



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Item ID:	D4323-10	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Ceiling, Outboard RH					
Start Date:	3/3/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/11/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 — inspected to P03 0.00 Dry only 8/103/08 (40) -20							
130 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							11/3/08 SP
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/5/10 RD2370 C211/03/08

POSITIVE RECALL

EFFECTIVE 11/03/03

RELEASED

AUTH

DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 10:03:06 AM

Page 1

Work Order ID: 66989

Parent Item: D4323-10

Parent Item Name: Ceiling, Outboard RH



Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.02 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	1,019.537	18.99	19.98947			



6185 KYDEX .080"



B11-3-7

Location

Loc Qty

Loc Code

therm

1019.537564

109703

81.189115

116576

938.348449

116576

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

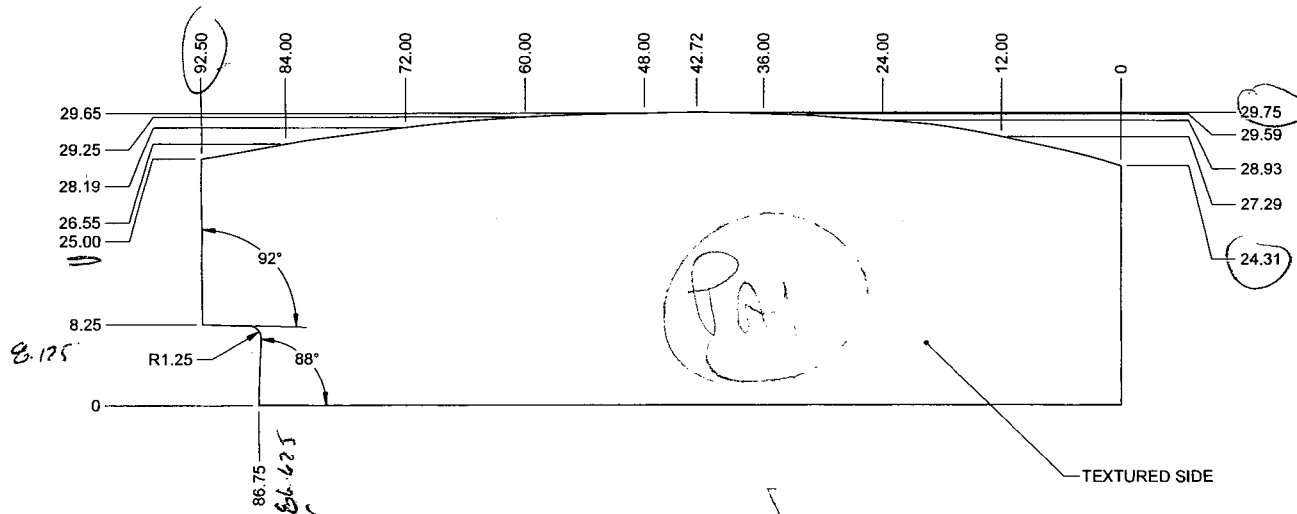
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66-989



D4323-10 CEILING, OUTBOARD RH

**PRELIMINARY
ISSUE**

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P1-HAIRCCELL, IVORY #62015
REF DART SPEC MKYD6185S.080-P1-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 7.39 lbs
- 8) TOOLING: THERMOFORM -10 PART PER MOLD DTXXXX. TRIM PER MOLD

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. PA3
MFG. APPR.		D4323	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
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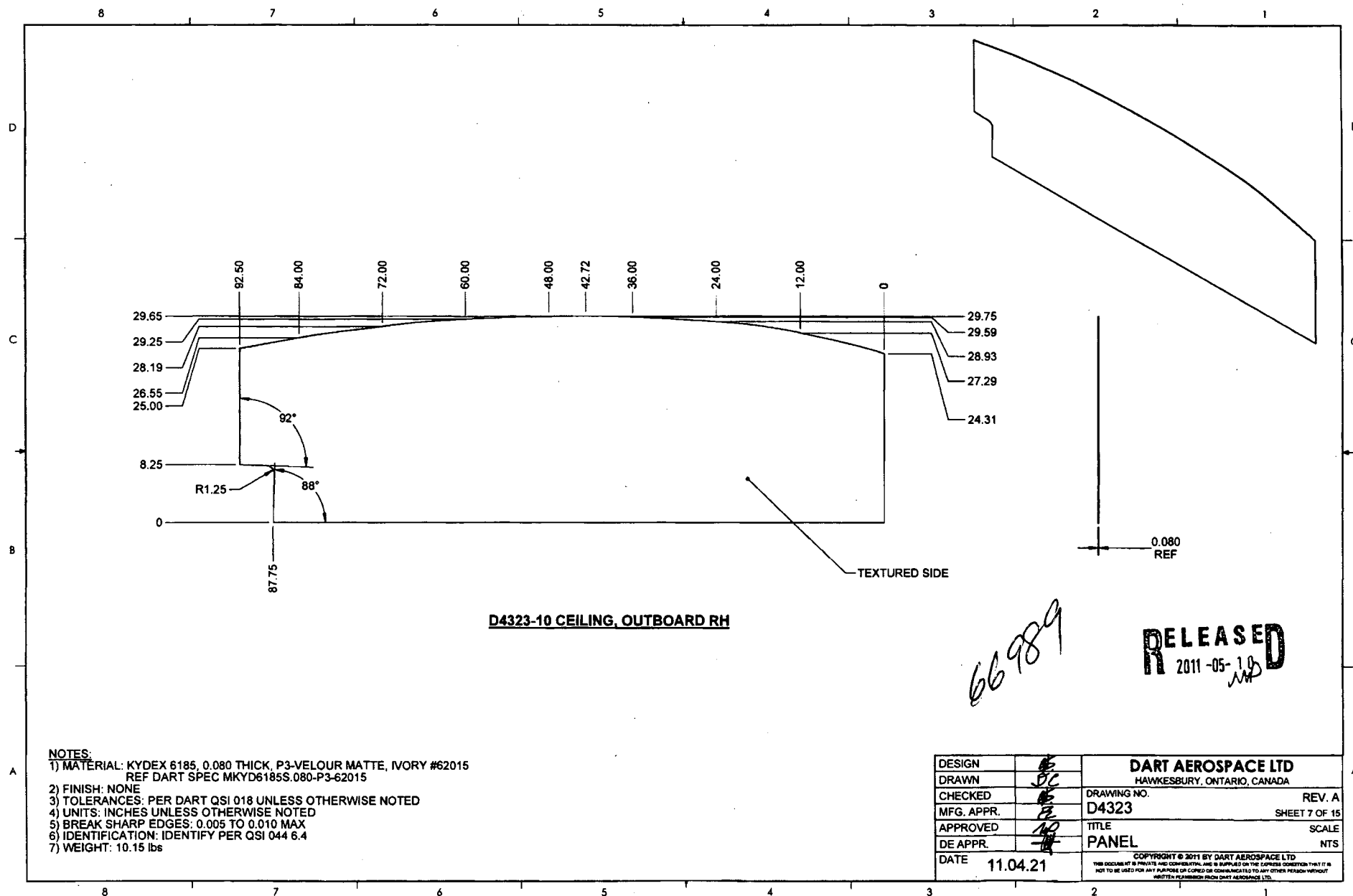
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 10.15 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4323	SHEET 7 OF 15
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RELEASED
2011-05-13

66989